

Safety and Operations Manual

15 Foot Flex-Wing Rotary Cutter

Bush-Whacker mowers from Hall Manufacturing have been popular for decades for highway right-of-way use. Lately, they have been increasingly in demand for agricultural, commercial and other applications where a heavy-duty, rugged mower is needed. The Bush-Whacker is available in a range of sizes to fit your needs — from the five-foot model all the way to the big 20-footer.

Hall Manufacturing has been in business for more than 75 years. During this time they've sold more than 10,000 units and are used in 27 states in the U.S.



- 3/16" Deck
- Structural frame of mower is 2" by 3" tubing with 1/4" wall thickness
- 1/4" I-Beam sides instead of 1/4" flat steel
- Gearboxes are mounted to 1/2" plates that are welded to the 3/16" deck
- 6 bolt mounting on gearboxes — heads are tack-welded to bottom of deck so one man can tighten the nuts or change the gearbox
- Blades are 1/2" by 4" instead of traditional 1/2" by 3 1/2"
- Hinges — 3" by 4" tubing with grease fittings

Welcome

Thank you for selecting the T-180 Rotary Mower. Your machine has been carefully inspected by both the factory and the dealership prior to being received by you to ensure that it is ready for operation.

This manual explains the proper operation of your machine. It is very important that you read and understand these instructions before operating or maintaining the machine. Failure to do so could result in personal injury or even death to you or passersby. Consult your Bush-Whacker dealership if you do not understand the instructions in this manual or need additional information.

Hall Manufacturing, Inc. reserves the right to make changes at any time without notice or obligation. Additional copies of the manuals are available from your local Bush-Whacker dealer.

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Safety Section

General Safety Instructions and Warnings



Attention

Important Safety Information

Read and Study this safety information BEFORE operating this equipment.



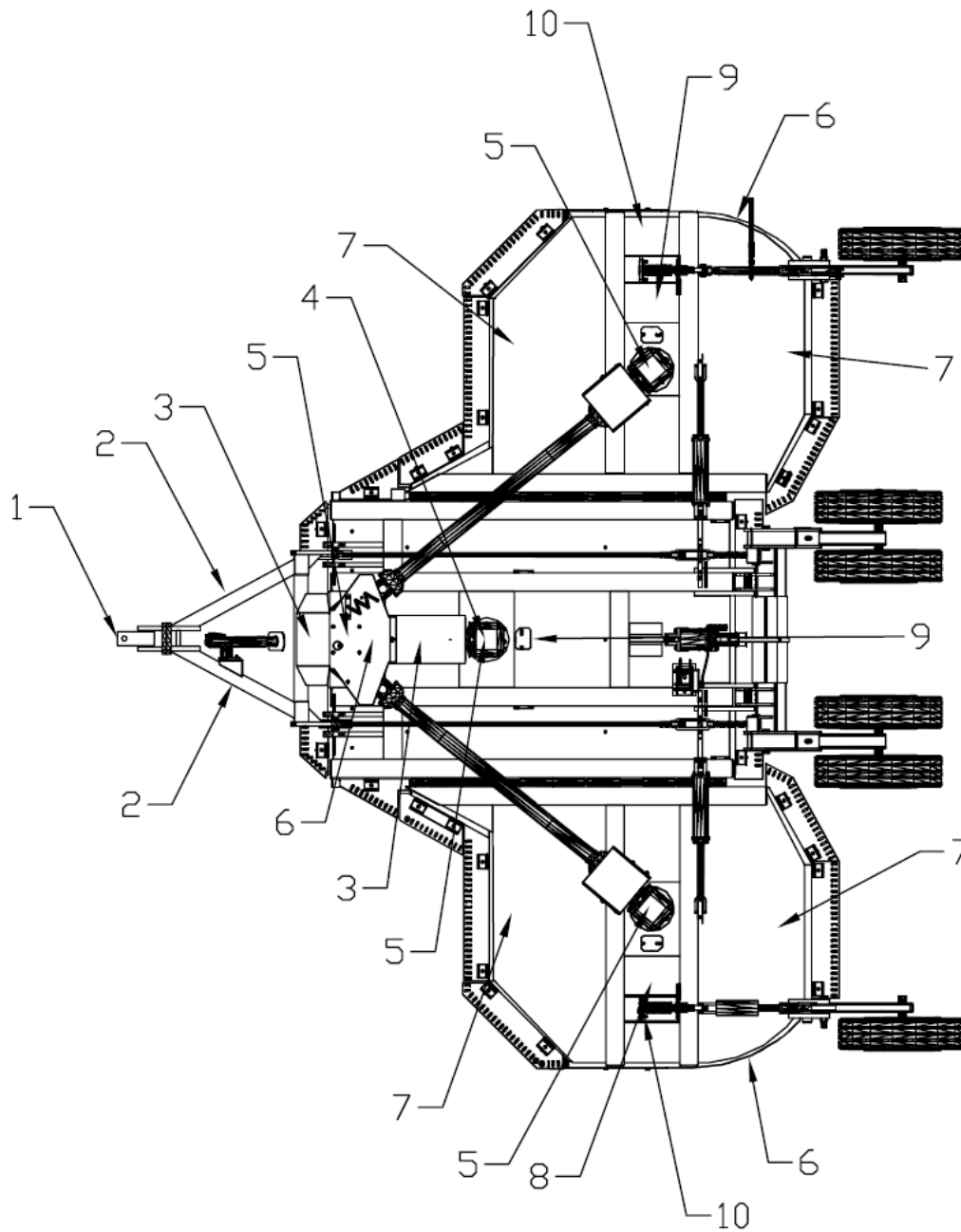
The use of common sense and reasonable safety precautions are a must in the operation of this equipment. Think Safety – Accident prevention is dependant upon the personnel involved in the operation, transport, and maintenance of the equipment. To minimize the chance of accidents, serious injury, or even death; Safety Precautions Must Be Followed! **FAILURE TO FOLLOW SAFETY INSTRUCTIONS AND FAILURE TO USE COMMON SENSE COULD RESULT IN SERIOUS INJURY AND/OR DEATH TO THE OPERATOR, BYSTANDERS, PASSERSBY, OR ANIMALS IN THE AREA.**



Safety Decals Information

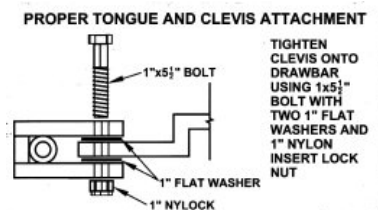
- Always keep the area around safety decals clean and free of debris so that they can be easily seen and read.
- When installing new components to the equipment, it is necessary to obtain new safety decals from your Bush-Whacker dealer and adhere them promptly and properly.
- Always keep safety decals clean, using soap and water. Do not use abrasive cleaners because they could cause damage to the decals.
- If the safety decals get damaged, or are missing, contact your local Bush-Whacker dealer to order replacements for them.
- In order to replace the safety decals, the equipment must be clean and dry. Then remove the adhesive backing and place it on the equipment.

Safety Decal Placement

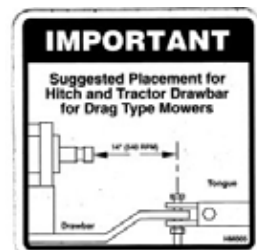


Safety Decal Placement

#1
Part# 4478



#2
Part# 4479



#3
Part# 2569



#4
For 540 RPM
Part# 4169



For 1000 RPM
Part#4170

#5
Part# 4416



#6
Part# 4415



#7
Part# 2572



#8
Part# 4167



#9
Part# 4168



#10
Part# 4480



Safety Warnings

Operations

NEVER operate a rotary mower with a person or animal in the area. The blades may throw objects for great distances and can strike a person, passerby, or animal causing serious injury or death.



Stop operation of the machine for a passerby or if someone appears to be approaching the area. Objects can be thrown for hundreds of yards at great speed.



ALWAYS inspect the deflector shields and/or chain guards daily to ensure that they are in proper working order and that no chains are missing. If the deflector shields or chain guards are not operating correctly, chain links are missing, or the complete deflector shields or chain guards assembly is missing, do not operate the mower. **NEVER OPERATE THE MOWER WITHOUT CHAIN GUARDS OR DEFLECTORS IN PROPER WORKING ORDER.**

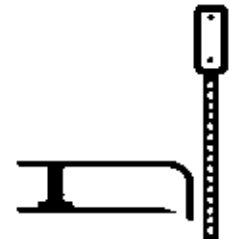
Rocks, gravel, wire, rope, bricks, or similar objects are potential hazards for rotary mowers operation. These items can cause damage to the machine; but more importantly, they can be ejected from underneath the mower at very high speeds, resulting in property damage, injury or even death. Always inspect the mowing area prior to the operation of any rotary mower. If any of these objects or similar objects are found, remove them immediately before operation.



NEVER operate the mower without the driveline safety shields in place and in proper working order. Operation without safety shields can lead to injury or death.

EXTREMELY IMPORTANT—Make sure all gearbox shields are in place and tightened before operating the mower. If one works loose, stop mowing and tighten immediately. **NEVER OPERATE THE MOWER WITHOUT ALL GEARBOX SHIELDS PROPERLY INSTALLED. OPERATION WITHOUT SAFETY SHIELDS MAY CAUSE SERIOUS INJURY OR DEATH.**

Avoid hitting hard solid objects such as large rocks, concrete culverts, guard rails, etc. This could cause serious damage to the machine. Broken machine parts or pieces of the object can be thrown at very high speeds. This could result in serious injury or death to persons at a considerable distance from the rotary mower.



NEVER ALLOW ANYONE TO RIDE ON THE MOWER OR THE TRACTOR. This equipment, if not operated properly, could be potentially dangerous; therefore, **NEVER ALLOW A CHILD TO OPERATE A ROTARY MOWER.**

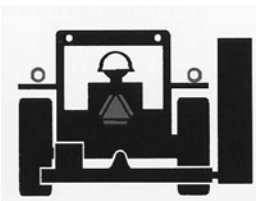
Safety Warnings

Operations



Thoroughly examine the rotary mower each day before operating. Tighten loose bolts, nuts, and hydraulic fittings. Replace all damaged or broken parts, including hydraulic hoses. If rotary mowers are not kept in proper working order, they could be damaged and this could result in serious injury.

NEVER engage in repair work under the mower deck or any other part of the mower that is raised off the ground until the mower is safely and securely supported in the raised position. Inadequate support can result in the mower falling, which could result in serious injury or death.



Use **proper signage** around working area. This will help the operator have a safe place to work, and help passers by to take appropriate precautions.

Use the proper **reflective devices** on the equipment to help prevent accidents.

Make sure that all rules of the road are followed, and Slow Moving Vehicle (SMV) rules are also observed



Always inspect the area before mowing for potential mower hazards. Remove or avoid all foreign objects such as wire, cable, metal objects, and all other foreign material. **Failure to do so could result in serious injury to the operator or passerby from foreign material being thrown from the mower.**

If operating along roadway, keep equipment within the **lane closest to the work area**. Never operate equipment against the flow of traffic, which could possibly result in a head-on collision causing serious injury or death.



Never use equipment around railroad tracks without direct railway supervision. Inexperience in railway operations may cause loss of communications, loss of signals, rail and tie damage or derailment.

NEVER cross railway tracks anywhere other than at normal traffic crossings. Unauthorized machinery on railways are in extreme danger of being struck by locomotives and railway machinery resulting in damaged equipment, serious injury or death.

Safety Warnings

Attaching/Detaching Cutter

Before approaching any rotary mower or before dismounting the tractor, always make sure of the following:

The tractor transmission is in the parking gear, and the parking brake is set to keep the tractor from moving while unattended.

The tractor PTO is disengaged.

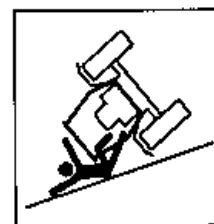
The engine has stopped, the key is out of the ignition, and all moving parts (both tractor and mower) have completely stopped. The rotating parts of the tractor and rotary mower may continue to rotate after the PTO has been disengaged. **THE OPERATOR SHOULD REMAIN SEATED UNTIL ALL MOVEMENT HAS CEASED!**



NEVER WORK ON THE ROTARY MOWER WITH THE POWER ON.

Rollover

Care must be taken when operating on uneven terrain, ditches, or embankments. The chances of the tractor and/or mower rolling over are increased. Also, the chance of objects being thrown by the blade are increased when operating under these adverse conditions.



Safety Warnings

Rollover



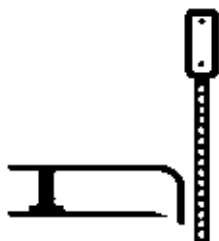
Never operate the equipment without the **Roll-Over Protective Structure (ROPS)** and **without a seat belt**. These items prevent injury in a roll-over accident. It is also highly recommended to wear protective equipment such as a hard hat, safety glasses, safety shoes, and ear plugs.

OPERATE CAREFULLY! It is important to slow down when turning and when going down slopes. Doing so could result in a roll over resulting in injury, or possibly death, to the operator.



Rotating Blades

Stay away from rotating blades. **Keep hands and feet clear of rotating blades and discharge areas at all times.** Never get close to the blades until **all motion has stopped and machine is turned off.**



Never allow **rotating blades** to **contact solid objects** like rocks, posts, curbs or guard rails. **Only operate if all guards and deflectors are in place and in good working condition.**

Never operate equipment with loose blades. Retighten after the first 8 hours of use and after blade replacement.

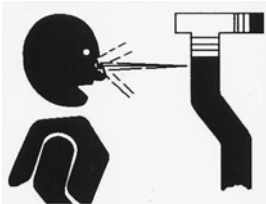


- Never operate with mower deck raised if bystanders or traffic are in the area. This helps to prevent injury or death from objects thrown by the blades.
- Stop cutting if someone comes within 300 feet. **DO NOT operate equipment with bystanders in the area!** Rotary mowers have the ability to throw debris considerable distances when blades are allowed to strike foreign objects. Operator must exercise caution or serious injury or even death could result.

Safety Warnings

Hydraulics

Relieve all pressure in the hydraulic lines by setting the mower deck on the ground, shutting the tractor off, and actuating lift valve handles before disconnecting hoses. This relief of pressure will reduce possibility of serious injury from spewing hydraulic fluid.



Frayed, torn, or crimped hoses may rupture and spray boiling oil onto the operator and cause serious bodily injury from scalding.



Failure to inspect and repair or replace hoses may cause worn hoses to **rupture suddenly** and **violently** resulting in **serious bodily injury** from **scalding or fire** with resulting burn injury or death.

Boiling oil may spray onto hot tractor parts and **catch fire** causing severe burn injury or death.



Inspect hoses daily and repair or replace when needed. Stop all leaks. Repair or replace hoses as indicated to prevent unexpected failure and possible serious injury to operator or bystander.

Use paper or cardboard to check for leaks. Never use your hand. If **oil penetrates skin**, gangrene or other serious injury could occur. **If skin is penetrated by hydraulic fluid, get immediate medical attention.**



Safety Conclusion

Now that the operator has read the information provided in this manual; he or she should now be aware of how dangerous a rotary mower can be if operated improperly. It is important that the operator of this equipment should be cautious, conscientious, and use common sense when operating this equipment in order to avoid serious injury and or death to the operator, support personnel, passersby, or animals.

**Safety
Depends on You!**

General Maintenance

General Maintenance

Refer to tractor's service manual for proper tractor maintenance.

NEVER service the mower with the power on, except where otherwise stated.

Before working on a mower always check to see that:

- The tractor's transmission is in the parking gear and the parking brake is set. This helps to keep the tractor from moving while unattended.
- The tractor PTO is disengaged.
- The engine is off and all moving parts (both tractor and mower) have completely stopped.

ALWAYS install transport locking bars before doing any wing blade maintenance.

The rotating parts of the tractor and mower continue to rotate after the PTO has been disengaged. The operator should remain seated until all movement has ceased.

Never engage in repair or service work under the mower deck or any other part of the mower that is raised off of the ground until the mower is safely and securely supported in the raised position.

Use extreme caution when working on a mower. Many of the parts are heavy and sharp and can cause serious injury if they are dropped or fall on the operator or bystander.

The blades are very sharp and can pivot. Use extreme caution when performing maintenance on them. Failure to do so could result in serious injury or possibly even death.

Use marfac double ought grease or cotton picker spindle grease to lubricate all Bush-Whacker gearboxes. Replacement gearbox grease is available from your Bush-Whacker dealership.

Always use genuine Bush-Whacker replacement parts, available through the network of authorized dealers. The use of non-OEM parts could void the warranty of this machine. Non-OEM parts, specifically blades and blade bolts, may not meet Hall Manufacturing Inc. specifications and could lead to serious injury or death.

At Least Twice Daily

Rotor Bar Assembly, Blades, Blade Bolts, and Nuts

- Check blades for any signs of cracking or damaged cutting surfaces. If a blade is cracked, replace the set at once. DO NOT operate the mower at any time with a cracked or severely damaged blade! If a blade breaks, it could cause severe injury or possibly death.
- Check if blade cutting surfaces are dull. If they are, re-sharpen or replace blades.
- Check if blade bolts and nuts are loose, cracked or damaged. DO NOT operate the mower with any of those characteristics. Any of these conditions could allow the blade to come loose and could cause injury or possibly death. Always keep the blade bolts and nuts tightened to 350 ft. lbs. of torque.
- DO NOT operate the mower with just one blade.

At Least Twice Daily

Rotor Bar Assembly, Blades, Blade Bolts, and Nuts

- Make sure rotor bar assembly is securely attached with castle nut and cotter pin to the output shaft.
- Always make sure to replace the blades in sets.

NOTE: When mowing at low cutting heights or on uneven terrain, the blades can come in contact with the ground frequently. When this happens, the blade tips can be pushed upwards causing the blade to bend. By pushing upwards on the blade tip, the rear of the blade (at the bolt hole) is forced downward away from the rotor bar assembly. This causes the bolt to be pulled through the bar and can cause it to shear. When the bolt shears, it will throw a blade. When operating in these conditions, the operator must check the blade bolts more frequently than normal, at least four times a day.

Always use genuine Bush-Whacker replacement blades, bolts, and nuts. Other blades may not meet Hall Manufacturing specifications and could lead to serious injury or death.

After changing blades, always check to be sure they are rotating in the proper direction (center and ring wing CCW and left wing CW). Improper rotation will cause the blades to “lay the grass down” and not cut properly.

Hydraulics

- If at any time the hoses become frayed, worn, or pinched, replace them.

Daily

Shields

- Make sure ALL shields are in place and tightened before operating the mower. If one works loose, stop mowing and tighten immediately.
- Replace shields if there's any damage or excessive wear.

Drive Shafts

- Inspect the Drive Shaft Shields, make sure that they are installed and working properly. If shields become damaged or loose during operation, stop immediately and fix or replace them.
- Make sure the drive shaft shield mounting chains are securely fastened.
- Inspect cross kits
- Grease each zerk fitting with natural or synthetic lubricants. Never mix the two types of lubricants.
- Check Drive Shaft tubes to ensure that they telescope properly. If they do not, replace them.

Daily

Gearboxes

- Check gear lube. If the grease is lower than the inspection plug on the rear side of the gearbox, then fill to the level of the plug. NOTE: Do not overfill the gearbox.
- Inspect output shaft for vines, wire, rope, etc. that may collect around the shaft and tear up the output seal. If a seal is leaking, replace it, or risk overheating and severe damage to the equipment.
- Check the mounting bolts and nuts to be sure that they are correctly secured. If left unchecked, it could cause excessive vibrating which could damage the equipment.

Pins, Bolts, and Nuts

- Inspect all pins, bolts, and nuts, making sure that they are all in place and secure. Look for loose fasteners and tighten to the proper torque as required.

Skid Shoes

- Check for any wear or damage, replace if required.

Frame

- Look for any structural cracks, damage and wear.
- Keep the equipment clean. Inspect for debris caught in the machine, especially at all pinch points.

Wheel Hubs

- Grease wheel hubs at zerk fitting once a day before operating the mower. Check seals for leakage. Replace seals if a leak is detected. Also, check bearings for damage. If they have seized, they are damaged; replace them immediately before use.

Chain Guards

- Rear and front chain guards are standard equipment for all Bush-Whacker rotary mowers.
- Always inspect the chain guards to be sure that no chain links are missing and the guards are operating correctly. If the guards are not operating correctly, links are missing, or the complete chain guard assembly is missing, do not operate the mower. **Never operate the mower without chain guards or deflector in proper working order.**

Hinges

- Grease hinges each day before operating the mower. This will ensure proper action of the hinges and pins. Also clean any build up of dirt and grime from the hinges. This build up can cause the hinges to work improperly and damage the machine.

Every 1,000 Hours or Annually

It is recommended to do annual, pre-season maintenance at the end of each operating season, rather than at the beginning.

The mower should be stored in the off-season **cleaned, inspected and repaired**. This will help prevent any rust forming on the mower's surfaces and contaminants damaging the hydraulic components.

2707 & 2758 Gearbox Disassembly Procedure

1. Remove 3/8" bolts from input cap. Remove the input cap taking care not to damage the seal in the cap.
2. The input shaft assembly can now be removed. To disassemble the input shaft assembly it is not necessary to remove the retaining ring. The bearing will press off of the ends of the shaft and the gear will slide off.
3. The output gear will slide off of the output shaft.
4. Remove the 1/2" bolts from the output cap and remove the output cap; once again take care not to damage the seal.
5. The output shaft assembly will have to be pressed out from the inside or it can be pulled out. The bearings will need to be pressed off.
6. If any of the bearing races either in the housing or in the input cap need to be removed, a blind hole bearing puller should be used.

2707 & 2758 Gearbox Assembly Procedure

1. The output assembly goes into the housing first. If the upper bearing race has been pulled out it must be pressed in. After the bearings are pressed onto the output shaft, the shaft can be inserted into the housing.
2. The lower bearing race will have to be pressed into the housing until it is flush with the bottom surface of the housing. Using the same number and thickness of gaskets replace the output cap. The 1/2" bolts are torqued to 60 foot pounds.
3. The bearing preload is measured by rolling torque. The rolling torque should be between 6-15 inch pounds. If the rolling torque is too high the output cap will need to be removed and an additional gasket added. When a gasket is added the lower race will need to be pulled out slightly. If the rolling torque is too low or there is any movement of the output shaft, a gasket will need to be removed.
4. Once the preload is set, remove the output cap. Install the seal into the cap and apply sealant to the gaskets. Replace the output cap, making sure the torque is correct.
5. Slide the output gear onto the output shaft in the housing.
6. The bearing race for the rear bearing on the input shaft must be pressed in.
7. Slide the input gear onto the shaft to the retaining ring. Then place the spacer above the gear. Press the bearing on the front of the input shaft. Lastly, press the bearing onto the rear of the shaft.
8. Place the input shaft assembly in the housing and check the gear mesh and back lash. The gear mesh is correct when the back surface of the gear teeth are level. The back lash should be between 0.006" and 0.014" when measured at the pitch diameter of the gear set. If the gear mesh or back lash are incorrect use shims to correct.
9. Press the bearing race into the input cap. Using the same number and thickness of gaskets, place the input cap on the housing. Torque the 3/8" bolts to 25 foot pounds.
10. The bearing preload is measured in the same manner as for the output shaft. The rolling torque should be between 11-25 inch pounds. Refer to step 3 for correction of the preload.
11. Once the preload is set, remove the input cap. Install the seal into the input cap and apply a sealant to the gaskets. Replace the input cap taking care not to damage the seal. Check the position of the oil plugs on the input cap. The oil level check plug should be just below and to the right of the input shaft, with the fill plug directly under the input shaft. Torque the bolts back to 25 foot pounds.
12. Fill the gear box with the recommended lubricant in an upright position similar to the mounting position. Fill the gearbox to the level plug (1/8" pipe plug). Check the lubricant with a dipstick (a small piece of wood works well as a dipstick).

Disassembly and Assembly Procedures for 2966 Divider Box

Disassembly:

1. Remove 3/8" bolts from wing output cap
2. Remove wing output cap assembly
3. Fold down locking tab of retaining washer
4. Remove locknut
5. Remove lock washer and flat washer
6. Remove gear
7. Remove output seal
8. Press shaft out of cap
9. Use the above steps for both wing output caps
10. Turn the remaining housing around to remove input shaft
11. Remove pressure relief plug
12. Remove 3/8" bolts from input cap
13. Remove input cap
14. Remove input shaft from housing
15. Press bearing cones off of input shaft from both ends
16. Remove gear
17. Remove 3/8" bolts from the center output cap
18. Remove output cap
20. Remove output shaft seal from cap

Assembly:

1. Make sure all gasket surfaces are clean and smooth
2. Insert output shaft seal to center output cap
3. Apply sealant (Permatex #2C or equivalent) to output cap gasket face
4. Place gasket (1) to cap
5. Place cap on housing
6. Replace 3/8" hex head bolts and torque to 25 foot pounds
7. Place input gear on input shaft
8. Press bearing cones onto shaft
9. Position input shaft in housing carefully without damaging output seal
10. Insert input seal into input cap
11. Insert bearing cup in input cap
12. Replace input cap gaskets
13. Attach cap to housing, torque bolts to 25 foot pounds
14. Set bearing pre-load as low as possible to eliminate end play in input shaft
15. Adjust pre-load
 - a. Add gaskets to reduce pre-load
 - b. Remove gaskets for reduction of end play
 - c. Remove bolts and input cap
 - d. Apply sealant to cap face

2966 Disassembly and Assembly Procedures for Divider Box

16. Remove bolts and input cap
17. Apply sealant to cap face
18. Attach cap with 3/8" input bolts
19. Torque bolts to 25 foot pounds
20. Press bearing cups into output cap
21. Insert shaft into cap and press bearing cones onto shaft
22. Place gear on shaft
23. Place flat washer on shaft end
24. Place lock washer on shaft end with the flare side pointed outwards.
25. Place lock nut on shaft tighten as required for bearing pre-load
 - a. Bearing pre-load is set same as input shaft
 - b. Bend up tab on retaining washer into nut slot to lock
 - c. Replace output shaft seal
 - d. Place assembled cap onto housing using same number and thickness of gasket removed
 - e. Check backlash (.006 to .015) with dial indicator, adjust by varying gasket thickness
 - f. Remove output cap assembly and apply sealant to output cap gasket face
 - g. Insert pressure relief plug

Operational Tips

Operational Tips

Tractor PTO Operating Range

This mower can be ordered from the factory as either a 540 or 1000 RPM machine. Always make sure that the tractor and mower have the same PTO speed. Check the tractor manufacturer's instruction manual for the proper engine RPM to achieve the proper PTO speed. **DO NOT** operate the mower at any higher RPM, doing so will cause damage to the mower as well as create an extreme hazard to the operator, passersby, or animals. Also note that doing so will void the warranty of the machine.

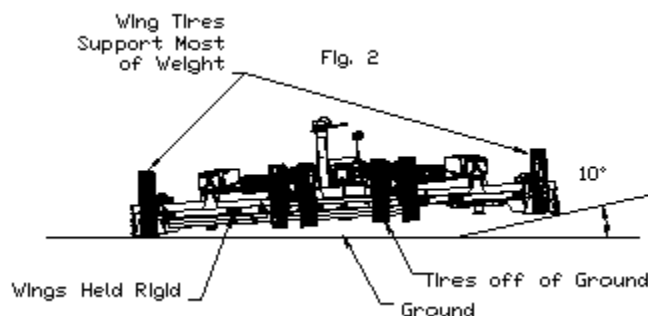
Drive Lines

Do not operate the main drive shaft or wing drive shafts at more than a 35 degree angle. Doing so will cause them to fail. Exception: the optional constant velocity main drive shaft has a maximum operation angle of 80 degrees.

Never lift the wings of the mower while the PTO is engaged. Always make sure that the blades have come to a complete stop before raising the wings. Doing so will cause extreme damage to the drive line and gearboxes

Wing Cylinders

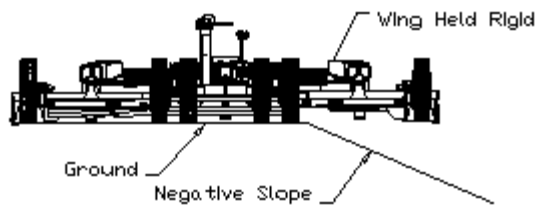
The wings are designed to follow the contour of the ground. In order to accomplish this, the spool that operates the wing cylinder must have a detent position. If the wings are not allowed to float, two things will happen. First, while mowing on a positive slope as illustrated in Fig. 2; the wing axle arms are supporting most of the weight of the entire machine.



With most of the weight on the outside tail wheels, the center wheels are left unsupported. Second, when the mower is mowing on a negative slope as illustrated in Fig. 3; the wing is suspended by the hinge. Both of these conditions become further complicated by the dynamic load created by traveling.

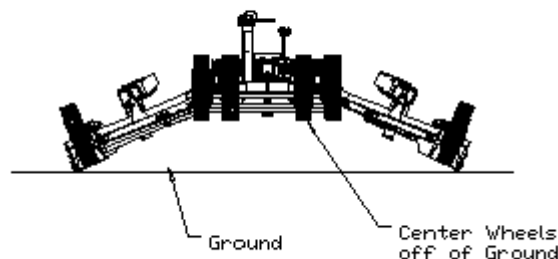
Operational Tips

Fig. 3



Never make the cylinder double acting where it can move in either direction the pull or push position. As illustrated in Fig. 4, when the wing cylinders are engaged in the push direction while the wing tire assemblies are on the ground; the center section becomes suspended by the hinge assembly.

Fig. 4



Hydraulic System

Always plug any unused ports of your hydraulic valve. If any port is left open, hydraulic fluid will spray from the valve and may cause an eye injury or become harmful if swallowed.

If the valve “screams” when operated, adjust the valve relief plug until the noise has stopped. This noise indicates the hydraulic fluid is bypassing internally making the cylinder not work properly. When the mower is in operation, the wing control valve handles should be in the forward most position. This is the float position and allows the wings to follow the contour of the ground. If you are having trouble with your valve operating the mower properly, check to be certain that you have an open center valve with an open center tractor or you have a closed center valve with a closed center tractor. An open center system will not work on a closed system tractor.

Operational Tips

Cylinders

Always have a breather plug installed on the cylinders. If there is no breather, the cylinder will not operate properly and may be damaged. Also, always have a restrictor installed between the valve and the cylinder. Hall Manufacturing, Inc. recommends installing the restrictor between the hose and the cylinder at the cylinder port. Never operate the mower without a restrictor, the wing will lower too quickly and will damage the mower. If you are having trouble with the cylinders raising the center section, check the relief plug on the valve to be sure the hydraulic fluid is not by-passing.

Transporting

Always secure the two wing sections with the travel safety bars when transporting the mower or performing maintenance on either wing section. This is of utmost importance, because the hydraulic system may fail and allow the wing to fall causing injury or death.

Leveling the Mower and Setting the Cut Height using the Optional Re-phasing Cylinder System

In order to achieve an even cut it is important to make sure that the mower is level from front to back and from side to side. Front to back leveling is achieved by adjusting the turn-buckle on the leveling rods located on the center section of the mower. The leveling rods should be shortened if the front is too low and lengthened if the front is too high. It is important to mention that this adjustment should take place with all of the tension removed from the level rods.

In order to level the machine from side to side it is important to understand that the rephrasing system uses a closed circuit hydraulic system which keeps the mower level at all cutting heights. When the center lift cylinder is activated, it in turn activates the right wing rephrasing cylinder which then activates the left wing rephrasing cylinder. When the system works properly, the wing sections should be at the same cutting height as the center section of the mower. If the wing sections are not completely level with the center section, the operator can adjust the wing up or down by adjusting the clevis end of the rephrasing cylinder. It is very important that this adjustment should only take place when all of the weight has been removed from the cylinder by raising the wing section off of the ground. Refer to the proper spacing of the clevis at the bottom of page 25.

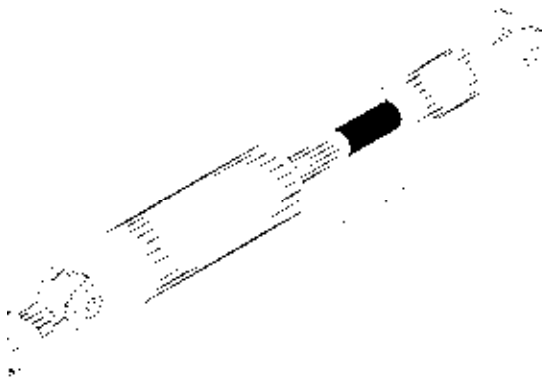
When all three sections are level, the cutting height can be set by activating the center cylinder to the desired height of cut. In order for the mower to lower to the proper cutting height, a stroke control kit can be installed on the center cylinder which limits the collapsed length of the cylinder.

Operational Tips

Re-phasing Cylinder System Set Up

- Hook up all hydraulic hoses as shown in the Parts Manual. If you are using a tractor with a three spool valve built into the tractor, then the hose which controls the up and down motion of the wings should be hooked into the “free floating” port of the tractor. The fluid from this hose must be allowed to flow freely to and from the tractors hydraulic tank. For set up on a T120/T168, disregard the left wing re-phasing cylinder and hose.
- Lower the wing sections
- To prime the system, activate the center lift cylinder until it has reached its full stroke. In this position, fluid will be allowed to bypass over the piston and into the right wing re-phasing cylinder. Once the right wing re-phasing cylinder and hose have been filled, fluid will then bypass over the piston and begin to fill the left wing re-phasing cylinder. When this cylinder and hose have been filled, it will continue to pass fluid to the tractor. Allow fluid to bypass for an additional two minutes.
- Repeat the previous step to be sure all of the air is out of the system.
- Set the desired cutting height by extending the center cylinder until the desired cutting height is achieved. Place a stroke control segment part# 2374 over the rod between the clevis and barrel on the center cylinder only.
- Adjust the wing shock absorbing system until the wing sections are level with the center section. Note: This must be done with the center section set at the desired cutting height.

This system is activated by simply using the middle handle on the valve to activate the center cylinder. When the center cylinder piston is pushed out by the tractors hydraulic system, hydraulic fluid will move to the right wing cylinder and force the piston to move. The fluid coming out of the right wing cylinder will then go to the left wing cylinder. This movement will then dump the holding fluid back to the tractor. When the center cylinder is allowed to retract, the fluid in the re-phasing system will move, allowing the re-phasing cylinder pistons to retract, keeping the wings the same level as the center section.



Tire Size	X Dimension
20"	1 1/2"
26"	1"
28"	1/2"

Left and Right Lift Wing cylinders—Set screw

During the operation of the mower, the WING LIFT CYLINDER P/N 4879, the SET SCREW P/N 4882 holding the ROD CLEVIS P/N 4881 against the rotation of the ROD P/N 4880 can become loose, thus having a negative impact on the safe operation of the mower.

In order to fix this problem, please follow the steps below.

1. With the mower Left and Right Wings in the down position and the weight of each wing supported by the ground, disassemble the SET SCREW P/N 4882 located inside the ROD CLEVIS P/N 4881 using a 3/16" ALLEN wrench.
2. Using any solvent or cleaner, degrease and clean the SET screw of any particles, dirt or grease. After cleaning dry the set screw.
3. Do the same procedure described above with the ROD CLEVIS P/N 4881.
4. Check and, if necessary, adjust ROD CLEVIS P/N 4881 in or out on the ROD P/N 4880 to ensure the mower's Left Wing and the Right Wing are adjusted for a correct UP and DOWN position. This adjustment must be done with the Left and Right Wings in the DOWN position. After adjusting the cylinder clevis and rod, rise the wings to be sure they are properly adjusted.
5. Fill the ROD CLEVIS threaded hole with a drop of permanent thread locker. It is recommended to use LOCTITE 262 liquid THREAD LOCKER.
6. Mount and tighten the SET SCREW P/N 4882 into the ROD CLEVIS P/N 4881 threaded hole. Be aware that, when using the LOCTITE 262 THREAD LOCKER, the full strength of the assembly is reached after 24 hours. If using other similar compounds to LOCTITE 262, follow manufacturer instructions regarding the application and the curing time to full strength.

Warranty Section

HALL MANUFACTURING WARRANTY POLICY FOR BUSH-WHACKER ROTARY MOWERS

NEW EQUIPMENT WARRANTY

Subject to limitations and exclusions set forth herein, Hall Manufacturing Inc. warrants that if any component or part of a machine manufactured by Hall Manufacturing, excluding any mechanical gearbox or mechanical gearbox component used by Hall Manufacturing, proves to be defective in material or workmanship within one (1) year from the delivery date of the original sale to the end user, Hall Manufacturing will, at its option, either repair or replace the defective part without charge. In addition, Hall Manufacturing warrants that if any mechanical gearbox or mechanical gearbox component used by Hall Manufacturing on any Bush-Whacker rotary mower proves to be defective in material or workmanship within three (3) years from the delivery date of the original sale, Hall Manufacturing will, at its option, either repair or replace the defective mechanical gearbox or gearbox part without charge, except for rotary mowers sold directly to a state or related governmental agencies for which the mechanical gearbox or mechanical gearbox component warranty period is limited to one (1) year from the delivery date of the original sale. No payment will be made in lieu of repair of the machine.

LIMITATIONS AND EXCLUSIONS

If the equipment is used for rental the warranty period is ninety (90) days from the date of sale to the renter. This includes all mechanical gearboxes and their components.

This limited warranty covers defects in materials and workmanship in the parts manufactured or used by Hall Manufacturing excluding:

Damage resulting from accident, abuse, misuse, neglect or other than normal and ordinary use of the equipment.

Damage resulting from failure to use the product in accordance with the manufacturer's instructions.

Refer to the appropriate owner's manual for the Bush-Whacker mower model you purchased.

Hall Manufacturing shall be released from all obligations and liabilities under this warranty if:

The equipment had been operated with any accessory, equipment, component or part not manufactured by Hall Manufacturing or approved for use by Hall Manufacturing.

The equipment has been repaired, altered or modified without Hall Manufacturing's approval or if the equipment shall have been operated subsequent to its involvement in an accident or breakdown unless the Owner furnishes reasonable evidence that such repair, alteration, modification or operation subsequent to its involvement in an accident or breakdown was not a cause of the defect.

The Owner does not return, at Owner expense, the defective accessory, equipment component or machine to, or notify, an authorized Bush-Whacker dealer. The Owner shall be responsible for submission of reasonable evidence of proof of Date Discovery of said defect.

REPLACEMENT PARTS WARRANTY AND PARTS REPLACED BY WARRANTY

Hall Manufacturing further warrants that if any genuine Bush-Whacker part or component utilized by an authorized Bush-Whacker dealer proves to be defective in material or workmanship, within thirty (30) days of such utilization, Hall Manufacturing will, at its option, repair or replace the defective part without charge. Owner shall be responsible for all freight charges including labor to and from the place where the warranty work is performed.

WHAT YOU MUST DO TO ENFORCE THIS WARRANTY

Warranty services must be performed or approved by an authorized Bush-Whacker Dealer. The Owner must, at the Owner's expense, deliver, mail or ship the defective product together with the original Bill of Sale to any Authorized Dealer in the Owner's area.

Owner must pay any postage, shipping charges, insurance costs, freight and other expenses to and from the place where the warranty work is performed. If required to return equipment or any component or part to an authorized Bush-Whacker Dealer, Owner shall be obligated to pay any premium payable for overtime labor if overtime is incurred as a result or a request by the Owner.

UNAPPROVED SERVICE OR MODIFICATION

All obligations of Hall Manufacturing under this warranty shall be terminated if:

Service is performed by someone other than a Dealer authorized by Hall Manufacturing

Equipment is modified or altered in ways not approved by Hall Manufacturing.

ACCIDENTS AND NORMAL MAINTENANCE

This warranty covers only defective materials and workmanship. It does not cover depreciation or damage caused by normal wear, accident, improper maintenance, improper protection in storage or improper use. The cost of normal maintenance and replacement of service items such as: cutting parts, drive line cross kits and clutch pads, skid shoes, gearbox and drive line shields, tires, bearings, seals, chains, etc. shall be paid for by the Owner.

HALL MANUFACTURING WARRANTY POLICY FOR BUSH-WHACKER ROTARY MOWERS

DISCLAIMER OF IMPLIED WARRANTIES & CONSEQUENTIAL DAMAGES

Hall Manufacturing's obligation under this limited warranty, to the extent allowed by law, is in lieu of all warranties, Implied or expressed, **INCLUDING IMPLIED WARRANTIES OF MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE** and any liability for incidental and consequential damages with respect to the sale or use of the equipment warranted. Such incidental and consequential damages shall include but not limited to: transportation charges loss of income; rental of substitute equipment, and expenses due to loss, damage, detention or delay in the delivery of equipment or parts resulting from acts beyond the control of Hall Manufacturing.

IMPROVEMENTS OR CHANGES

Hall Manufacturing reserves the right to make improvements or changes in design and specification at any time without incurring any obligation to owners of units previously sold.

WARRANTY CLAIMS PROCEDURE

Warranty claims must be delivered to Hall Manufacturing within thirty (30) days after the warranty service work was performed.

Hall Manufacturing will approved or deny claim within thirty (30) days of receiving a claim.

Hall Manufacturing will issue credit for all genuine Bush-Whacker parts or components as well as all approved

Dealership employee labor time at a rate of \$30.00 per hour within thirty (30) days of the claim approval.

Defective parts must be held for inspection for ninety (90) days after the work is performed. Hall Manufacturing may request that parts be returned to the Hall Manufacturing factory for inspection.

ACKNOWLEDGEMENT REQUIRED

Hall Manufacturing shall have no obligation under this warranty unless the Owner Registration Card, included with your Operators Manual, is signed by Owner and Dealer or Dealer's Agent and is delivered along with a copy of the original Bill of Sale from the Dealer to Hall Manufacturing within sixty (60) days from the date of sale.

COMPLETE THE WARRANTY REGISTRATION CARD

(ON THE FOLLOWING PAGE)

PLACE IN AN ENVELOPE ALONG WITH THE ORIGINAL BILL OF SALE

MAIL TO:

HALL MANUFACTURING, INC.
P. O. BOX 5638
NORTH LITTLE ROCK, AR 72119

WARRANTY REGISTRATION

** Return to Hall Manufacturing within sixty (60) days of purchase

Date of Purchase _____ Purchaser _____

Address _____ City _____ State _____

Product _____ Model# _____ Serial# _____

Dealer _____

Address _____

City _____ State _____

Signature of Original Buyer

Signature of Dealer or Dealer's Agent

* Please include a copy of the original bill of sale

Notes

